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D3564-11
Job Sheet 191052



Part No: D3564-11

Job Qty: 8 pcs

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/21/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ Verified By:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs	3/18/19	3/18/19	0.00	1.39	Waterjet - Flow		JRB 05/29/19
120	QC 8	8 pcs	3/18/19	3/18/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
130	Small Fab - Brake NC - B4B	8 pcs	3/18/19	3/18/19	0.38	0.53	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		
140	QC 5	8 pcs	3/18/19	3/18/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		

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					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
150	Automated Welding - B4B	8 pcs	3/18/19	0.00 3.40	Automated Welding - 1 - B4B	
160	QC 10	8 pcs	3/18/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
170	QC 5	8 pcs	3/18/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
180	Spray Paint - 2 - B4B	8 pcs	3/18/19	0.00 0.80	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
190	QC 5	8 pcs	3/18/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	

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				QC 5 - 30	
200 Packaging 3-1 - Stock - B4B	8 pcs	3/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	FP-002
				Packaging 3 - 16 - B4B	14-6-4
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	8 pcs	3/18/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21 JUN 04 2019
				QC 21 - SA - 53	9-85

Part Op 100 - 1-Cut D3564-1 as per Dwg D3564 Dwg Rev: E Prog Rev: E 2-Deburr if necessary

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - Form on Brake as per Dwg D3564 using Jigs DT8179

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Automated welding) 1- AUTOWELD AS PER DWG AND QSI004 8259 HARDCOAT BATCH: _____

160 - (QC10- Inspect visual per QSI004- ground welds)

170 - (QC5- Inspect part completeness to step on W/O)

180 - (Spray Paint / NDT Room) APPLY COATING ON CONCAVE SURFACE AS PER DWG AND QSI005 (SEE NOTE 12 ON DWG) 5178350

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	11.2800 sf (1.41 ea)	100-Waterjet - Flow - 1	5159674

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	11	159	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	3.227inches $\pm$ 0.010	3.237 3.217	3.225	
2	Wearshoe	2.432inches $\pm$ 0.010	2.442 2.422	2.434	
3	Wearshoe	2.500inches $\pm$ 0.010	2.510 2.490	2.500 2.497	
4	Wearshoe	6.000inches $\pm$ 0.010	6.010 5.990	6.006	
5	Wearshoe	12.104inches $\pm$ 0.010	12.114 12.094	12.105	
6	Wearshoe	18.000inches $\pm$ 0.010	18.010 17.990	18.000	
7	Wearshoe	18.000inches $\pm$ 0.030	18.030 17.970	18.000	
8	Wearshoe	9.000inches $\pm$ 0.030	9.030 8.970	9.000	
9	Wearshoe	11.500inches $\pm$ 0.030	11.530 11.470	11.500	
10	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290	0.302	
11	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290	0.302	
12	Wearshoe	0.188inches $\pm$ 0.005 -0.001	0.193 0.187	0.189	
13	Wearshoe	0.375inches $\pm$ 0.010	0.385 0.365	0.375	
14	Wearshoe	0.063inches $\pm$ 0.010	0.073 0.053	0.060	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					



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Container No: S185053



Part: D3564-11

Job No: 191052

Serial No/Batch: S185053

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/29/19